

Work Order ID 154598

Thursday, December 15, 2016 1:34:01 PM

154598

Ship JAN 6

Page 1

Item ID: D3821-1KIV Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Panel W/O Rotor Brake-Ivory
Start Date: 12/12/2016 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 12/15/2016 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: DEC 15 2016 Tooling: _____ Date: _____ Run Start *NR1*
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3821	REv. B

100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

DAS
07
9-89

16/12/20

105

0.00

105

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per OSI022 KYDEX

DAS
07
9-89

16/12/20

Temp: 150 deg. F

Time IN: 5:00 PM

Time OUT: 6:00 AM

DEC 20 2016

Per.....

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DAS
07
9-89

16/12/21

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89		JAN 0 6 2017
180									
QC	Memo	0.02							
Quality Control									

DAS
21
9-89

JAN 0 3 2017

Picklist Print

Thursday, December 15, 2016 1:34:00 PM

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Work Order ID: 154598

154598

Parent Item: D3821-1KIV

D3821-1KIV

Parent Item Name: Panel W/O Rotor Brake-Ivory

Start Date: 12/12/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A New Issue DL
IPP Rev. B Add Step 105 Dry Material 10/04/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-62015		Purchased		No		100	sf	1,738.890	12.79	12.85427			DAS 07 9-89
MKYD6185S 080-P3-62015									**				
Kydex Ivory (52"x96"-.080)													

Location	Loc Qty	Loc Code
SHED	728	
m129761	347	
m130671	381	
therm	1010.89	
121755	13.44	
124462	997.45	

12.86 sg H

16/12/20

DART AEROSPACE LTD		Work Order: 154598
Description: Panel, without Rotor Brake		Part Number: D3821-1KIV/KGY
Inspection Dwg: D3821	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

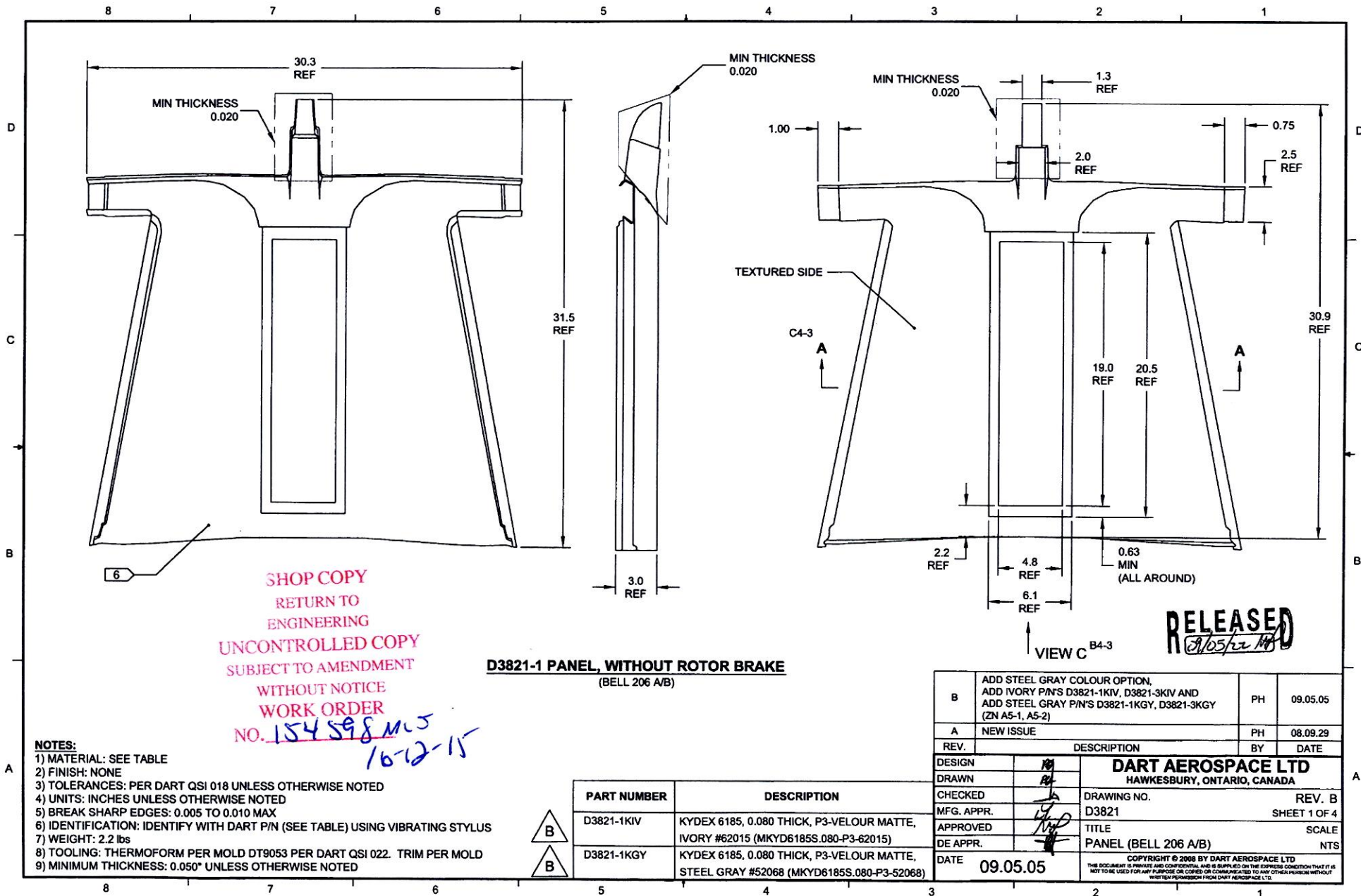
Measured by: DAS 07 9-89	Date: 16/12/20
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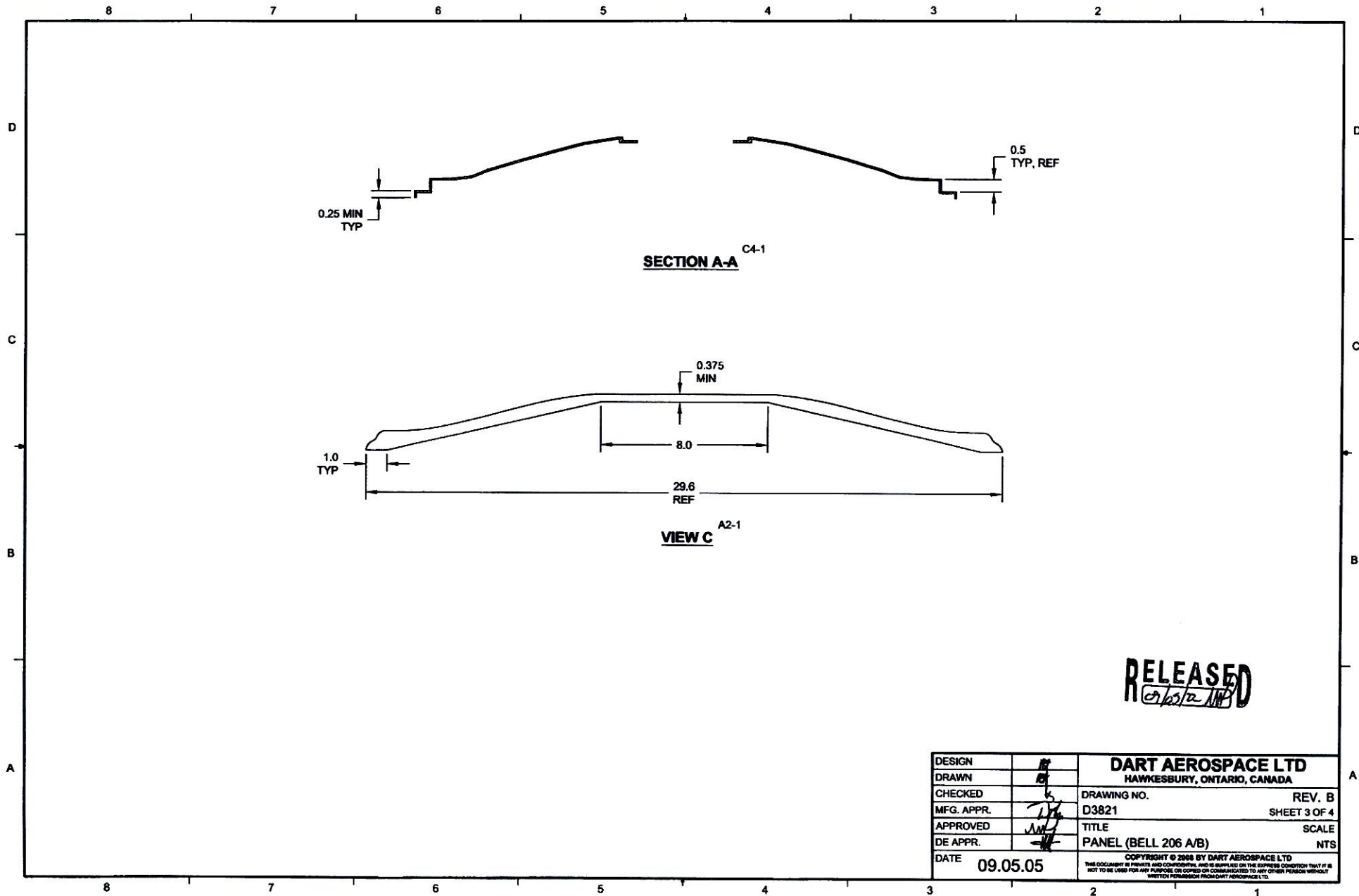
TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	Min	1.06"	✓			
0.75	Min	0.79"	✓			
0.63	Min	0.68"	✓			
0.25	Min	0.31"	✓			
0.375	Min	0.42"	✓			

Measured by: DAS 07 9-89	Date:
Audited by: DAS 9 9-89	Date: 16-12-22
Prototype Approval: 9-89 N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	





RELEASED
07/25/12

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3821	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		PANEL (BELL 206 A/B)	NTS
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